

Date: Wednesday, 04/06/2008 1:53:42 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MIRROR ARM LONG (S-76)
Job Number :	39700		
Estimate Number :	11893		
P.O. Number :		Part Number :	D2261
This Issue :	04/06/2008	Drawing Number :	D2261 REV A1
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	04/06/2008	Drawing Revision :	A1
Previous Run :	33329	Material :	
Written By :		Due Date :	11/06/2008
Checked & Approved By :	JUD 08.10.04	Qty:	5 Um: Each
Comment :	Est: D 02.04.15 Added dwg Rev.A1 NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 3.1281 f(s)/Unit Total: 15.6403 f(s)
 Material: 304/316 SS tubing 0.500" Dia. x 0.035" wall
 (M304TR0500W035) Batch No: M108215

SB 08/06/05 (S)

2.0	BRAKE NC	NC BRAKE
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Comment: BRAKE NC
 Punch tube 304/316 with 2B finish
 Form as per dwg D2261
 Deburr

FF 08-06-12

SB 08/06/05

2B 08/06/09 (S)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

08/06/12 (S)

4.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
 Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:00 a.m.
 320 °F
 11:30 a.m.

08/06/12

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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**Comment:** INSPECT POWDER COAT

08/06/12 (S)

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR ARM LONG (S-76)

Job Number: 39700

Part Number: D2261

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D2022101	Spacer
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Spacer

Pick:

Qty	Part Number	Description	Batch
4	D2022-101	Spacer	B37021

12/8/12 (5)

7.0	A1449	Grommet
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Grommet

Pick:

Qty	Part Number	Description	Batch
2	A1449	Grommet	14878

12/8/12 (5)

8.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D2261

FF 08-06-17 (5)

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08/06/17 (5)

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57229

FINAL INSPECTION/W/O RELEASE

12/8/20 (5)

11.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/06/23

Job Completion

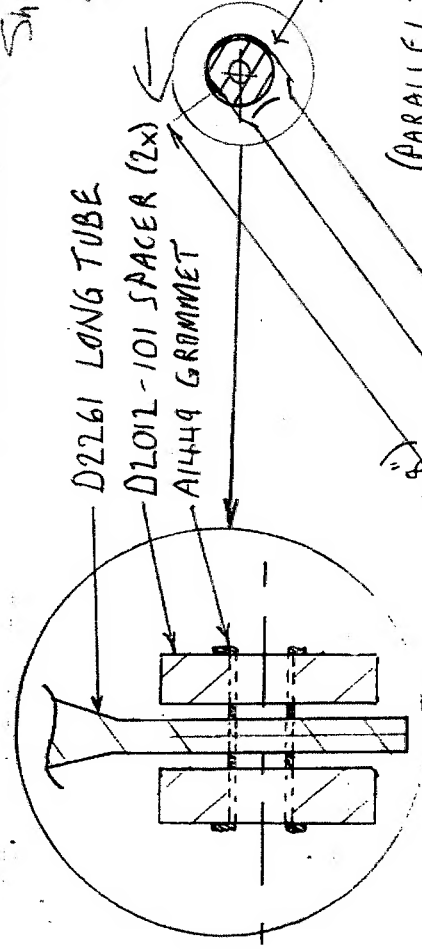


MF 08-06-20



DART

DRAWN <i>M. Cohen.</i>	DART AERO ACCESSORIES INC <small>VICTORIA INTERNATIONAL AIRPORT, CANADA</small>		
DESIGN	DRAWING NO. <i>022261</i>	REV. <i>A</i>	SHEET <i>1</i> OF <i>1</i>
	TITLE <i>LONG TUBE</i>		
Aug 10/94			
A1	0203.22	ADD FINISH	



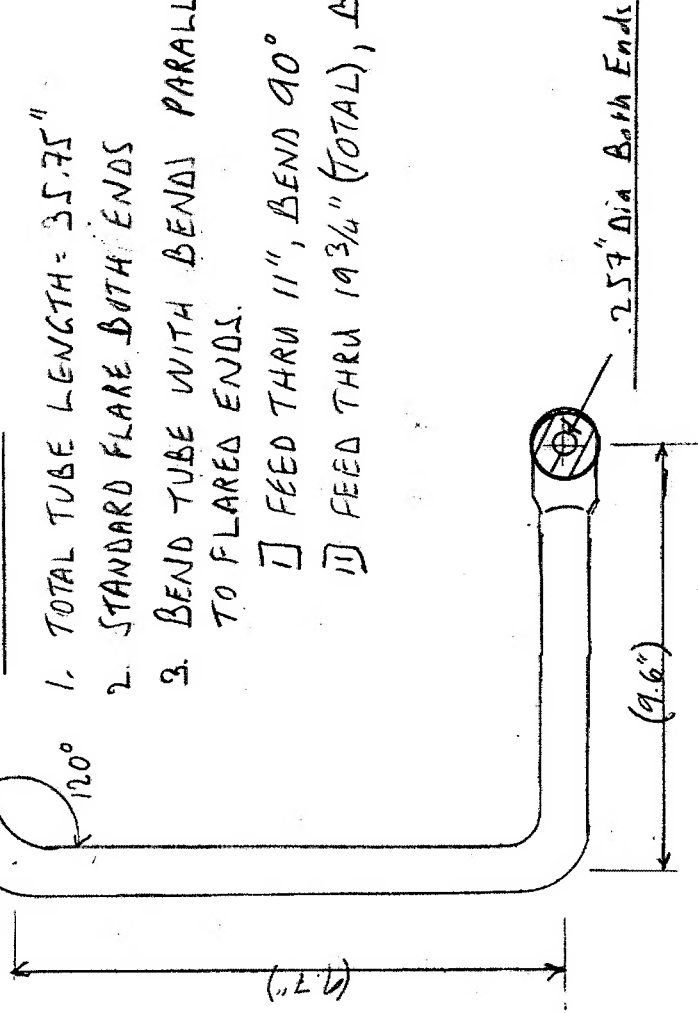
ASSEMBLE PER DETAIL
AND SWAGE GROMMET
(2 LOCATIONS)

STANDARD FLARE
BOTH ENDS
(PARALLEL TO PLANE
OF BENDING)

MATL: 304 SS 1/2" OD x .035" WALL TUBE
FINISH: POWDER COAT BLACK SANDTEX (43.5.7D)
PER DART QSI QCS 4.3 (A1)

PROCEDURE:

1. TOTAL TUBE LENGTH = 35.75"
2. STANDARD FLARE BOTH ENDS
3. BEND TUBE WITH BENDS PARALLEL TO FLARED ENDS.
 - I] FEED THRU 11", BEND 90°
 - II] FEED THRU 19 3/4" (TOTAL), BEND 60°



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WORK ORDER
NO. *38100*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries